

Work Order ID 67492

~~PRELIMINARY ISSUE~~

Wednesday, March 23, 2011 6:48:55 AM

Page 1

Item ID: D4323-22

Accept

Revision ID: PRELIM

Item Name: Corner Trim, Inner

Start Date: 3/23/2011 Start Qty: 4.00

Required Date: 3/25/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:



Reference:

Approvals:

Process Plan: HDate: 11-03-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4323	<u>PAS A</u>

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x21Sh
11/03/29

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°FTime IN: 4:00 pmTime OUT: 7:00 am11/03/28
11/03/29x21Sh
11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 67492

Wednesday, March 23, 2011 6:48:55 AM

Page 2

Item ID: D4323-22 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Corner Trim, Inner
Start Date: 3/23/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/25/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA104 using tool DT9729 Dwg Rev: <u>PAS</u> Folio Rev: <u>17</u>	0.00 0.00				<u>x4</u>			<u>DL</u> <u>11/03/29</u>
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00							<u>DL</u> <u>11/03/29</u>
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							<u>inspected to PAS</u> <u>Dwg only</u> <u>8/10/25</u> (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 67492




Wednesday, March 23, 2011 6:48:55 AM



Page 3

Item ID: D4323-22 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Corner Trim, Inner
Start Date: 3/23/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/25/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandThermo	Memo	0.00				x4			2M 4/03/29
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150  QC	Memo	0.00				x4			2M 4/03/29
Quality Control	Complete FAI document								
160  QC	Memo	0.00							
Quality Control									

QC5- Inspect part completeness to step on W/O 0.00 -inspector to PAS
0.00 Don only
8/10/29 (74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries





Work Order ID 67492

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Wednesday, March 23, 2011 6:48:55 AM

Item ID: D4323-22 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Corner Trim, Inner
Start Date: 3/23/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/25/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo <i>Revised 3/23/11</i>	0.00							<i>3/23/11</i> 
180  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							<i>3/23/11</i> 

POSITIVE RECALL

EFFECTIVE *3-23-11* AUTH *W*
RELEASED *W* DATE *4/05/15*

*PD2370**U 1103-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, March 23, 2011 6:49:02 AM

Work Order ID: 67492

Parent Item: D4323-22

Parent Item Name: Corner Trim, Inner

Start Date: 3/23/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: Rev. A New Issue 11/03/22 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	948.0376	3,540/6 2,666	11.22526			



6185 KYDEX .080"



Location

therm

Loc Qty

948.037564

81.189115

866.848449

Loc Code

109703

116876

14,1944

DL
u/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67492
Description:		Part Number:	D4323-22
Inspection Dwg: D4323 Rev: PAS		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/2</u> "	DL			
Shape Definition	DL			
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching	DL			

Measured by: <u>DL</u>	Date: <u>11/03/29</u>
------------------------	-----------------------

TRIMMING SECTION

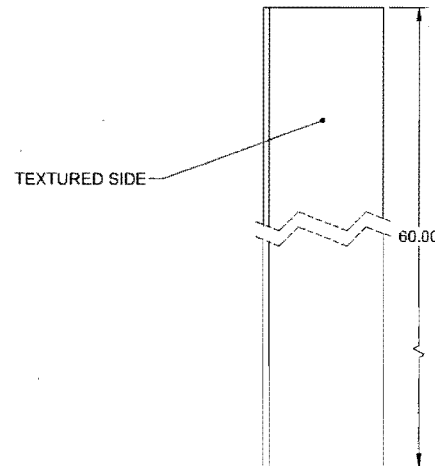
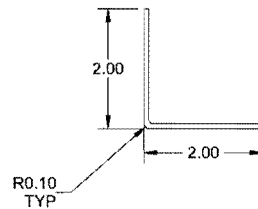
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00"	± 0.030	2.00"	✓		TAPE DL-01	
2.00"	± 0.030	2.00"	✓		TAPE DL-01	
60.0"	± 0.030	60.125"	✓	✓	TAPE DL-01	OK MP 11/03/29
0.140"	0.030	0.060"	✓		Uniq ED-6	

Measured by: <u>DL</u>	Date: <u>11/03/29</u>
Audited by: <u>S 12 PAS Day 4</u>	Date: <u>11/03/29</u>
Preliminary Approval: _____	Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

2001
10/10/01



D4323-21 CORNER TRIM, OUTER
D4323-22 CORNER TRIM, INNER (OPPOSITE)

SHOT COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 07492

2111-03-23

**PRELIMINARY
 ISSUE**

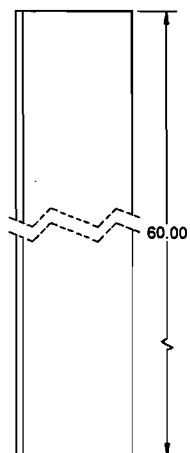
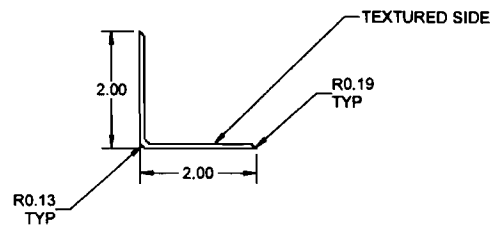
NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
 REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68
- 8) TOOLING: THERMOFORM -21 PART PER MOLD DTXXXX. TRIM PER MOLD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

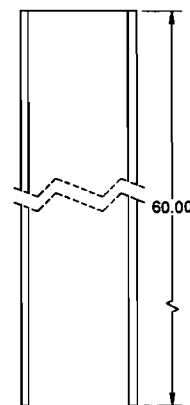
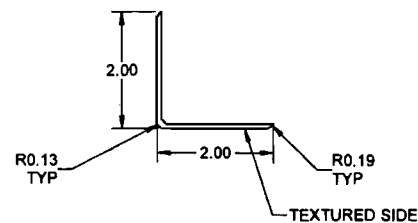
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED		DRAWING NO. D4323	REV. PA5 SHEET 13 OF 13
MFG. APPR.		TITLE PANEL	SCALE NTS
APPROVED		COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY REUSE OR DISCLOSURE OF THE CONTENTS HEREIN WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	11.02.09		

10-10-10
10-10-10

10-10-10
10-10-10



D4323-21 CORNER TRIM, INNER



D4323-22 CORNER TRIM, OUTER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.51 lb
- 8) TOOLING: THERMOFORM -21/-22 PART PER MOULD DT9729 AND DART QSI 022. TRIM PER MOULD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

RELEASED
R 2011-05-18
NM

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	D4323	SHEET 13 OF 15
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	PANEL	NTS
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